

Date: Wednesday, 21/05/2008 2:29:21 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 39379
 Estimate Number : 10804
 P.O. Number :
 This Issue : 21/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : CROSSTUBES
 Previous Run : 38508
 Written By :
 Checked & Approved By :
 Comment :

Drawing Name : D206-667-103

Part Number : D206667103
 Drawing Number : REWORK-ARM.SHIELD
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 28/05/2008 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-667-103A	CHG	CHG002
DESC	Crosstube Fwd High	STC	SH01-5
LOT	B35515	STC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			

Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
CHG002

08-05-22 JLD

2.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

RTN FROM OFFSHORE INVENTORY

1 X D206-667-103A B 35515 CHG002

08-05-26

(1)

3.0 D206667103A

Crosstube Fwd w/Armor Shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Installation W/ armour shield
 B/N 35515

08-05-26

(1)

4.0 SPRAY PAINTING

SPRAY PAINTING



Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE

DISCARD HARDWARE IF NO GOOD

KEEP CLAMPS AND SUPPORTS TO
REASSEMBLE

STRIP TUBE COMPLETELY TO
REMOVE ARMOR SHIELD

08-05-26

(1)

08-05-27

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/05/2008 2:29:21 PM
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Process Sheet

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Job Number: 39379

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



08-05-27 (1)



Comment: INSPECT WORK TO CURRENT STEP

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 05 27 (1)

7.0

QC14

INSPECT SPRAY PAINT



08-05-28 (1)



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

8.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

RE-ASSEMBLE

IDENTIFY ANY NEW PARTS USED:

MS21920-20 B106484

Abrasion strip: B35900

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ml 08 05 28 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/28 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ENSURE ORIGINAL KIT IN BOX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/05/2008 2:29:21 PM
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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103

Job Number: 39379

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

(X)

Identify and pack for shipping as per PPP D206-667-103 CHG002

Location:

PPP Rev:

B

8/5/29

SP

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/05/29 EC

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29 JH

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26**UNDER REVIEW**05-08-10 PH
re-draw detail F

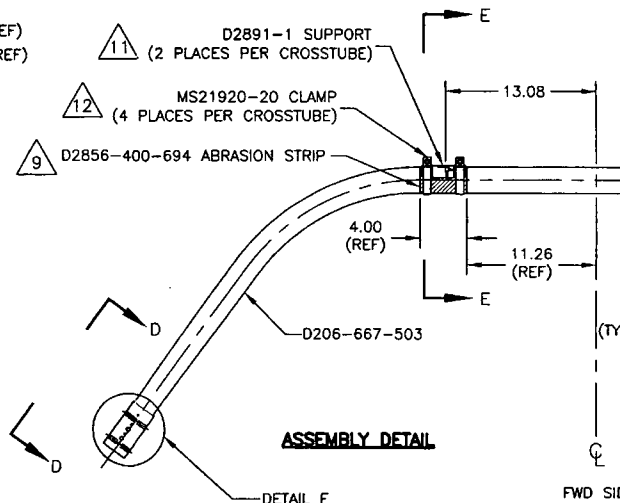
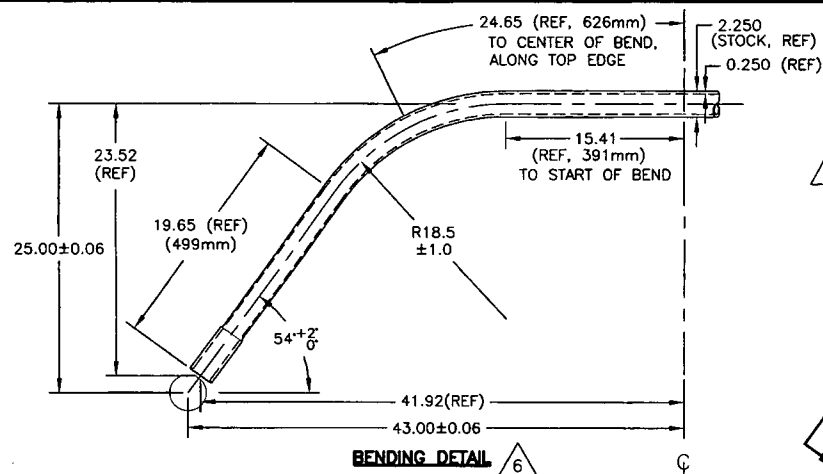
Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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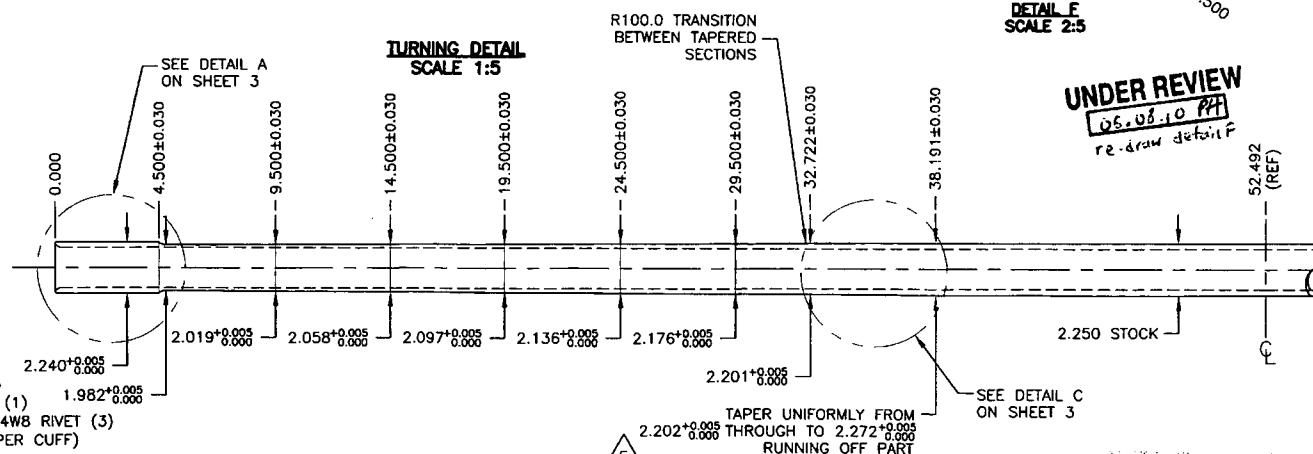
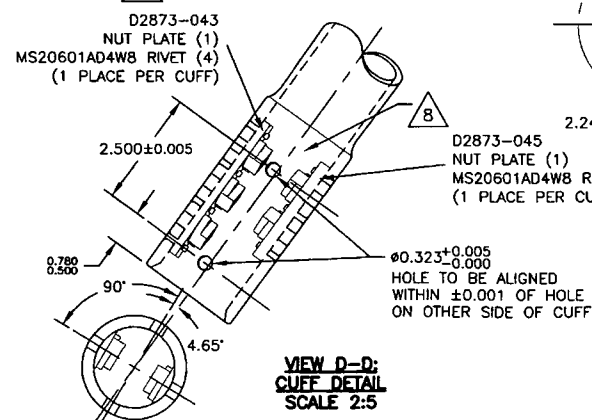
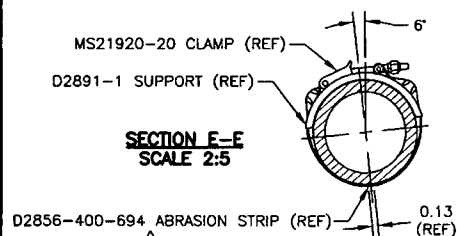


Ø0.323^{+0.005}_{-0.000}
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ±0.001
OF HOLE ON OTHER SIDE OF CUFF




PILOT Ø0.128
C'SINK Ø0.225X100'
(TYP 7 PLACES PER CUFF)

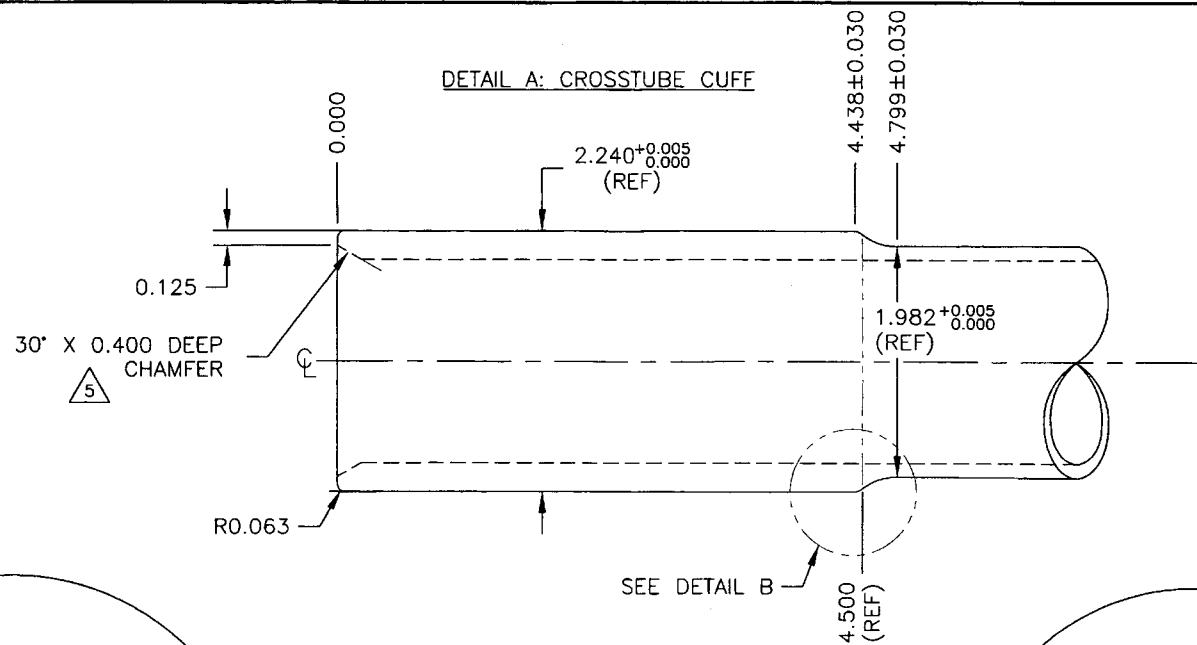
FWD SIDE ONLY

DETAIL F
SCALE 2:5



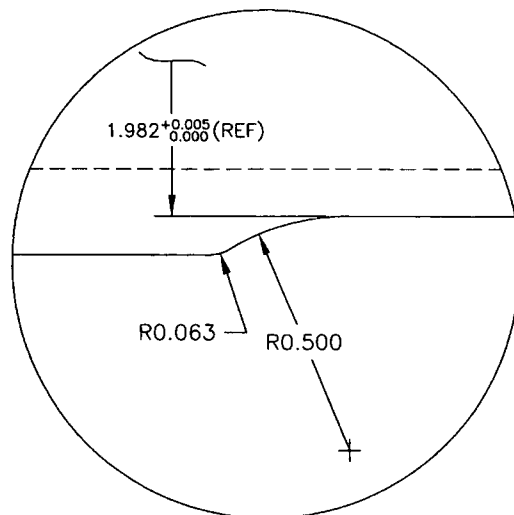
UNDER REVIEW
05.08.10 PH
re-draw detail F

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		CHECKED	APPROVED	DRAWING NO.	REV. 8
		 DS	 DS	D206-667-143	SHEET 2 OF 3
		DATE	TITLE	SCALE	
		05.07.26	CROSSTUBE ASS'Y (206L HIGH FWD)	1:10	

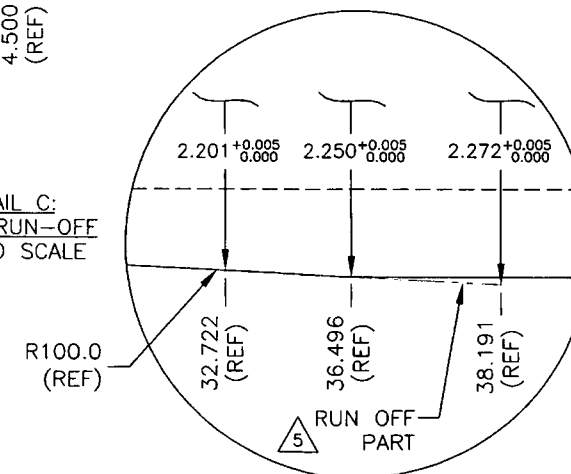


05.07.26 PH

UNDER REVIEW
06.08.10 PH
re-draw detail F



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN

PH

DRAWN BY

PH

DART

DART AEROSPACE LTD.

MARKHAM, ONTARIO, CANADA

CHECKED

PH

APPROVED

PH

DRAWING NO.

D206-667-143

REV. B

DATE

05.07.26

TITLE

CROSSTUBE ASS'Y (206L HIGH FWD)

SCALE

1:1

SHEET 3 OF 3



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200

CROSTUBE AFT HIGH

P/I/N: D206-667-203

B/I/N: B39379

CHG002

PART OPTICALLY IDENTIFIED PARTS SUPPLY ON REQUEST			
PN	D206-667-203		
DESC	Crosstube Aft High		
LOT	B39379		
MODEL	Bell 206J1/L1/L3/L4		
MADE IN CANADA			
Q16	Q16	Q16	Q16
CHG002	SH01-5	SR01304NY	
TELEPHONE: 1-800-363-3300			
0222291			